

Date: Friday, 22/05/2009 4:47:10 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE KIT FOR D206-642-511
Job Number	: 48171		
Estimate Number	: 12893		
P.O. Number	:	Part Number	: K642 511
This Issue	: 22/05/2009 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : SKIDTUBES	Drawing Revision	: N/A
Previous Run	: 47726	Material	:
Written By	:	Due Date	: 05/06/2009 Qty: 46 Um: Each
Checked & Approved By	: <u>JUD 09.05.25</u>		
Comment	: Est Rev.A 07.06.05 new issue EC Est Rev.B 08.02.05, Per ECN1080P LL		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Handwritten: JUD 09/06/03



Comment: DOCUMENT CONTROL

Create White labels per PPP K642-511 CHG003

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D206648013	GHW Modification
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

GHW Kit

Batch:

Handwritten: B47600

Handwritten: 9/6/5

Handwritten: 2098226/09/01

Handwritten: SP

4.0	D2652	Bushing
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2652

Bushing

Handwritten: B47649

Handwritten: 9/6/5

Handwritten: SP

5.0	D2712	Set Screw
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

10 D2712

Set Screw

Handwritten: 45249

Handwritten: 9/6/5

Handwritten: SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D29321

Saddle LH Out, 206



9/6/4



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-1

Saddle

47039

1345262

48188

SC

7.0

D29331

Saddle LH In, 206



9/6/4



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-1

Saddle

1347035

47569

SC

8.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

1347947

9/6/5

SC

9.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

1347948

9/6/5

SC

10.0

D29381

Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2938-1

Saddle

1347336

1348191

9/6/4

1348191

SC

11.0

D29391

Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2939-1

Saddle

1347115

9/6/4

SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 48171

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D33963

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3396-3

Spacer

1332336

2
155662

9/6/5

SL

13.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-043

Tow Ring

154578

9/4/4

SL

14.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

Washer

156752

9/6/5

SL

15.0

D34571

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3457-1

Washer

154793

9/6/5

SL

16.0

AN3C35A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C35A

Bolt

1110155

7
1109323

SL

17.0

AN3C36A

BOLT



Comment: Qty.: 9.0000 Each(s)/Unit Total: 54.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

9 AN3C36A

Bolt

1109171

15
110847

9/6/5

SL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN3C41A

BOLT



9/6/14



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

M1108409

50

19.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M111295

9/6/14

50

20.0

AN5C11A



(4) M110925

9/6/13



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M110847

(1) M1108428

50

21.0

AN5C12A



(4) M110925

9/6/13



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M110847

(2) M110847

50

22.0

AN5C13A



(4) M110925

9/6/13



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M1107800

50

23.0

AN5C15A



(4) M110925

9/6/13



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M1109148

9/6/13

(4)

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 48171

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN5C32A



9/6/3



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M110155

SL

25.0

AN5C34A



9/6/3



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M110342

SL

26.0

AN5C35A



9/6/3



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M107551

SL

27.0

AN960C10L

washer



9/6/3



Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

M111808

SL

28.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

M111916

9/6/3

SL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 48171

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

AN960C516L

WASHER



9/6/3



Comment: Qty.: 8.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C516L

Washer

M110139

23
M111650

SP

30.0

MS210433

Nut



9/6/3



Comment: Qty.: 20.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS21043-3

Nut

M111879

SP

31.0

MS210434

Nut



9/6/3



Comment: Qty.: 13.0000 Each(s)/Unit Total: 78.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

13 MS21043-4

Nut

M111819

SP

32.0

MS210435

Nut



9/6/3



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 MS21043-5Nut

M11119

SP

33.0

D36721

Phenolic Washer



B517628

9/6/3



SP

Comment: Qty.: 24.0000 Each(s)/Unit Total: 144.0000 Each(s)

PHENOLIC WASHER

34.0

D36723

Phenolic Washer



B517023

9/6/3



SP

Comment: Qty.: 24.0000 Each(s)/Unit Total: 144.0000 Each(s)

PHENOLIC WASHER

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 48171

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D36725

Phenolic Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

PHENOLIC WASHER

9/6/12

SD

38.0

D36727

Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

PHENOLIC WASHER

9/6/12

(4x)
SD

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

9/6/12 (4)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-511 CHG003

Location:

9/6/12

(4x)
SD

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/12 (4)

Job Completion



U 09/06/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries